



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. DSI 9337	REV. A SHEET 1 OF 1
DATE 06.06.01		TITLE CROSSTUBE INSTALLATION	SCALE NTS
A	06.06.01	NEW ISSUE	

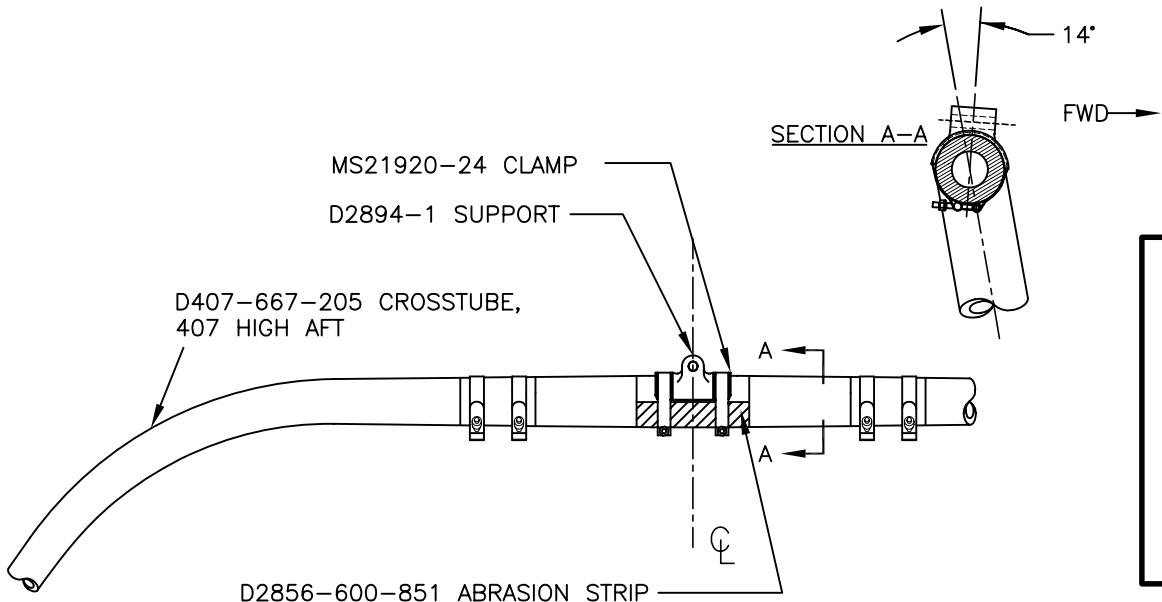
DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV.C OR EARLIER
 REF. CANADIAN STC: SH01-5
 REF. FAA STC: SR01304NY

Purpose: This modification can be made to prevent clamps on crosstube from slipping during service.

Procedure:

- 1) Remove the landing gear from the helicopter as per ICA-D206-667 section 32.1.
- 2) Remove the D2894-1 Support from the crosstube per ICA-D206-667 section 32.3.
- 3) Remove the existing D2856-600-851 Abrasion Strip per ICA-D206-667 section 32.5.
- 4) Cut new D2856-600-851 Abrasion Strip to fit the bottom half of the crosstube (cut approximately in half, see figure below) and install.
 - a. Ensure the surface of the crosstube is properly finished per ICA-D206-667 section 5.3.9.
 - b. Abrade area to which abrasion strip will be applied with 400 grit sandpaper.
 - c. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
 - d. Remove liner from the adhesive side of the Abrasion Strip.
 - e. Locate the Abrasion Strip on the crosstube per below. The Abrasion Strip should wrap around the bottom half of the crosstube on the opposite side of the D2894-1 Support. Align the Abrasion Strip with the surface and press one edge to surface with finger.
 - f. Squeegee remaining portion of the Abrasion Strip onto the surface using firm overlapping strokes and a 3M PA-1 Plastic Applicator or equivalent.
- 5) Apply a continuous layer of Proseal 890 or Sikaflex-241/291 or MIL-S-8802 Class 'B2' sealant to the underside of the D2894-1 Support.
- 6) Locate D2894-1 Support in the proper position per figure below. The support should be located so that it is angled forward 14° from the centre line of the crosstube.
- 7) Install the MS21920-24 clamps as shown in Figure 32-9 of ICA-D206-667. Tighten the clamps to a torque of 80 to 100 in-lb (9.0 to 11.3 Nm). Seal all edges of the supports and hardware with Sikaflex-241/291 or MIL-S-8802 Class B2 or Proseal 890 sealant.
- 8) Re-install landing gear per ICA-D206-667 section 32.2.



CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED 	
BY:	D. SHEPHERD (DE # 02)
DATE:	06.06.01
CERT. NO.:	SH01-5
ISSUE NO.:	3

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